

DT 8731

-001



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D2666-1**Job Sheet 190711****Part No:** D2666-1**Job Qty:** 4 pcs**Part Name:** Saddle, LH, Fwd, Aft, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/13/19**Job Tracking No:****Due Date:** 3/18/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	3/18/19		0.00	0.00	HAAS - 1		SBL 19/03/30
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	3/18/19		0.00	4.49	Conventional Mill - 1 - B4B		SBL 19/03/31
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	3/18/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S167963**Part:** D2666-1**Job No:** 190711**Serial No/Batch:** S167963**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 03/30/19

Plex 2/13/19 2:32 PM Dart.lajeunesse.marie

130 QC 8	4 pcs	3/18/19	0.00 0.00	QC 2 - 54	SBL 19/03/31
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	3/18/19	0.00 0.21	QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	MDL 19/04/32
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
150 Powdercoat - 1 White Gl(A)-B4B	4 pcs	3/18/19	0.00 0.18	QC 8 - 67	
				QC 8 - 47	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/04/03
				Handfinish - 1 - 11 - B4B	
160 QC 3	4 pcs	3/18/19	0.00 0.00	Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
SPART. 1.10 O.U.T. 320° FIDISH. 1.40				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	

					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
170 Packaging 3-1 - Stock - B4B	4 pcs	3/18/19	0.00 0.00		Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
180 QC 21 - SA	4 pcs	3/18/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAS
40
9-89
APR 03 2019

APR 04 2019

DAS
21
9-89
APR 04 2019

Part Op 100 - HAAS CNC Vertical Machine - Program batch number.

Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 pcs (1 ea)	100-HAAS 4 Axis	5133675

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	4	49	0

Part Specifications

Specifications could not be found.

Plex 2/13/19 2:32 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 190711
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.121	.122	.123	.122	
B	0.100	0.140		.118	.118	.118	.117	
C	2.470	2.510		2.495	2.495	2.495	2.495	
D	0.100	0.180		.132	.134	.134	.13	
E	0.210	0.230		.223	.223	.223	.223	
F	1.313	1.343		1.327	1.326	1.325	1.325	
G	0.240	0.260		.249	.249	.249	.246	
H	0.615	0.685		.660	.660	.660	.660	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.002	1.000	1.000	1.000	
K	0.235	0.240		.238	.239	.239	.239	
L	0.510	0.515		.510	.510	.510	.510	
M	0.100	0.120		.120	.120	.120	.120	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		6.002	5.996	5.996	5.998	
P	1.245	1.255		1.256	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.494	.497	.496	.498	
S	0.312	0.318		.312	.312	.312	.312	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.549	.550	.550	.548	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 57	Date: 19/03/31
Audited by: [Signature]	Date: 14/04/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					